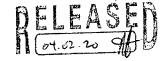
29

DART AEROSPACE LTD	Work Order:	21176.	
Description: Bearpaw Kit (48" x 19") 205/430	,	Part Number:	K10015
Dwg: D2521 Rev. H		Qty:	5 Kits
Ref: K10015 Rev. A; DSK086-6 Rev. A	/		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler	1.1		7.7
		Note: (1) K10015 Kit consists of Qty (2) D2521	delt	04.07.05	5
		Dwg not required	7 7	04,07.00	
2	DC	Photocopy bluefile: K10015	IA		
		D205-564-011 D430-688-011	90	1 .	_
		7 1	/	04.07.07	6
		and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)	12m		
3	GA	Cut 2 blanks per (1) K10015 Kit			
"		Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per			
	·	DSK086-6	(4)	NINDE	
1		Material: Black UHMW 1"	d	JUND	5
		(MUHMWB10) · Batch: 15075			
4	M∨	Inspect material for defects or damage prior to machining	3	XIMIX	6
	D 4) (Machine as as Falis FA000 and B. B0504	a,		
5	MV	Machine as per Folio FA222 and Dwg D2521	5/	orlala	<
6	QC2	Identify as D2521	The same of the sa	Off BOOK	
0	QC2	Inspect parts as they come off the CNC machine	5/	Whilm	5
7	MV	Deburr	11/1		
			X J	H199191	5
8	MV	Form as per Dwg D2521 using bending Jig DT8328	20	x/AVA	
	0000		10	71090/	\mathcal{O}
9	QC8 & 5	Second inspection	1	2108.10	5
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material	100	,	
		from step 3)			
		Qty Part Number Description Batch	1.		
	` \	8 D2182B055 Rubber Cushion B20434			
]	^	16 D2274. Radius Block B20927			
		2 D2521 Bearpaw 331176 16 D2529 Washer B20964A			:
		16			
	,	16 AN4-15A Bolt m13437/m12903/m7809	114<04		j
	`	16 AN960JD416 Washer WISO20	11311		ļ
	\	16 MS21042L4 - Nut (or -4) - 14764			
		1 Paperwork package from Step 2	11.1	1	_
-		,	CZ	01/80/10	<u>)</u>
11	QC4	Inspect Kit for 100% Completeness on the W/O	lu	04/28/10	5
12	PK	Identify and pack for shipping as per PPP K10015	dJ	01/02/12	-
13	AC	Cost / part 396, 0 0	Ca	עון נשורט	
14	DC	Close W/O 3 8 4.7 8	Syc	04-8-13	7
14	DC	Inspect Level 21		M m II	5
		Change Rev	AM	CHOO W	5
Rev	Date	Change	ised By	Appro\	/eď

Rev	Date	Change Change	Revised By	74-68 €16 5 . Approved
Α	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
В	03.05.26	Reformat; Incorporated D2521	KJ/RF	
С	04.02.17	Tolerance added to Step 3	KJ/JLM	-#-



Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector			
	:									

NCR WORK ORDER NON-CONFORMANCE								
DATE STEP		Description of NC section A	Intial	Corrective Action Section B Sign & Intial Date			Approval Design Mgr	Approval QC Inspector
						18/14/14/14/14		
		·		,				

PAR#:	Fault Category:	DQA:	Date:
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NOTE: Date & initial all entries H:Admin-QA\ISO\forms\w/oncB.doc

QA: N/C Closed: _____ Date: ____

DART AEROSPACE LTD	Work Order:	21176
Description: Bearpaw	· Part Number:	D2521
Inspection Dwg: D2521 Rev: H		Page 1 of 1

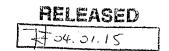
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	11991	1 /		-	
В	5.600	+/-0.030	12 29				
C	11.500	+/-0.030	1/2/97				
D	10.250	+/-0.010	10 320				
E	13.250	+/-0.010	13 250	1/			
F	8.500	+/-0.010/	7 6M	<u> </u>			
G	22.125	+/-0.030	55 124	, _			
H	8.75	+/-0.010	2-11		-		
1	44.500	+/-0.030	14:500	4			
J	6.688	+/-0.030	6.109	1/			
K	5.625	+/-0.030	5.619	1/			
L	7.000	+/-0.030	7.000	1/			
M	5.000	+/-0.010	5,000	1/			
N	4.000	+/-0.030	3.993	1/			
0	6.625	+/-0.030	6,623	1/			
Р	19,000	+/-0.030	19,008	1/			·
Q	0.31 x 45°	+/-0.030	1314	1/			-
R	0.19 x 45°	+/-0.030	175	1/			
S	0.50 x 45°	+/-0.030	(00)				
Т	0.38 x 45°	+/-0.030	1370	V.			
U	0.063 x 45°	+0.030/-0.010	1063				
V	Ø0.260	+0.005/-0.000	,262				
W	Ø0.93	+/-0.030	,923	1			
X	0.30	+0.030/-0.010	1370	2/			:
Υ	0.375	+/-0.010	1373	i/			
Z	0.750	+/-0.030	145	1/			-
AA	0.250	+/-0.010	0245	-V			
AB	4.000	+/-0.030	3,494	آ ر			
AC	6.625	+/-0.030	6,623	~			
AD	0.950	+0.030/-0.010	0947	1			
AE	0.375	+/-0.010	.373				
AF	3.399	+/-0.030	3.599				
AG	6.625	+/-0.030	6,623	1			

Measured by:	Audited by:	$\mathcal{A}_{\mathcal{B}}$	Prototype Approval:	N/A
Date: 19/19/15	Date:	4.06.10	Date:	NA

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	P/0 K10015	KJ/RF	de



Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Jul 01, 2004 02:00 pm

Work Order No : 0021176

Project Name : K10015 Project For : WK429

Project For : WK429 Work Order Type : Main .

Main WO Number

House Part Number: *K10015 Description: Bearpaw Kit

Manufactured : Yes

Amount Req'd : 5 Amount Done : 0

Start Date : 07-01-04 Est Finish Date : 07-16-04

Act Finish Date

Drawings Reqd : No

Ok for Approval

Approval Rec'd

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date

Invoice Number:

Invoice Amount: 0.00

Order Entry No:

OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

•		Estimated	Actual	Var. %	Posted	To Post
	===		========	=======		
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	*	·
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========		======		
Burden	:	0.00	0.00	0.00		
•		·========	.========	======		
Total Cost	:	0.00	0.00	0.00		
Marqin	:	0.000	0.000			•
Selling Cost	:	0.00	0.00			,

		Estimated	Actual
Labour Hrs/Amount Done	:	. 0.00	0.00
Profits/(Loss)	:	0.00	0.00